

Date: Wednesday, 2/20/2008 4:20:29 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 37520	
Estimate Number : 10144	
P.O. Number :	Part Number : D20136
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 36919B	Material :
Written By :	Due Date : 3/20/2008 Qty: 4 Um: Each
Checked & Approved By : <u>AS 080221</u>	
Comment : Est Rev: A New Issue 05-11-01 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 7.2660 f(s)  
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing  
 (M304TR0.750W.049)  
 Batch: M107518

SB 08/07/10 (4)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

- 1-Punch as per template D2013-T5 and Dwg D2013
- 2-Flatten ends of D2013-6 tube as per Dwg D2013 using DT8545
- 3-Bend tube as per Dwg D2013 using Jig DT8201 Identify as D2013-6.
- 4-Deburr as required

SB 08/04/14 (4)

FF 08-04-15

SB 08/09/14 (4)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/07/10 (4)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1 SEE SECOND SHEET.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:20:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 37520

Part Number: D20136

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



4.0

ST 241

*[Signature]* 8/2/11

(4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

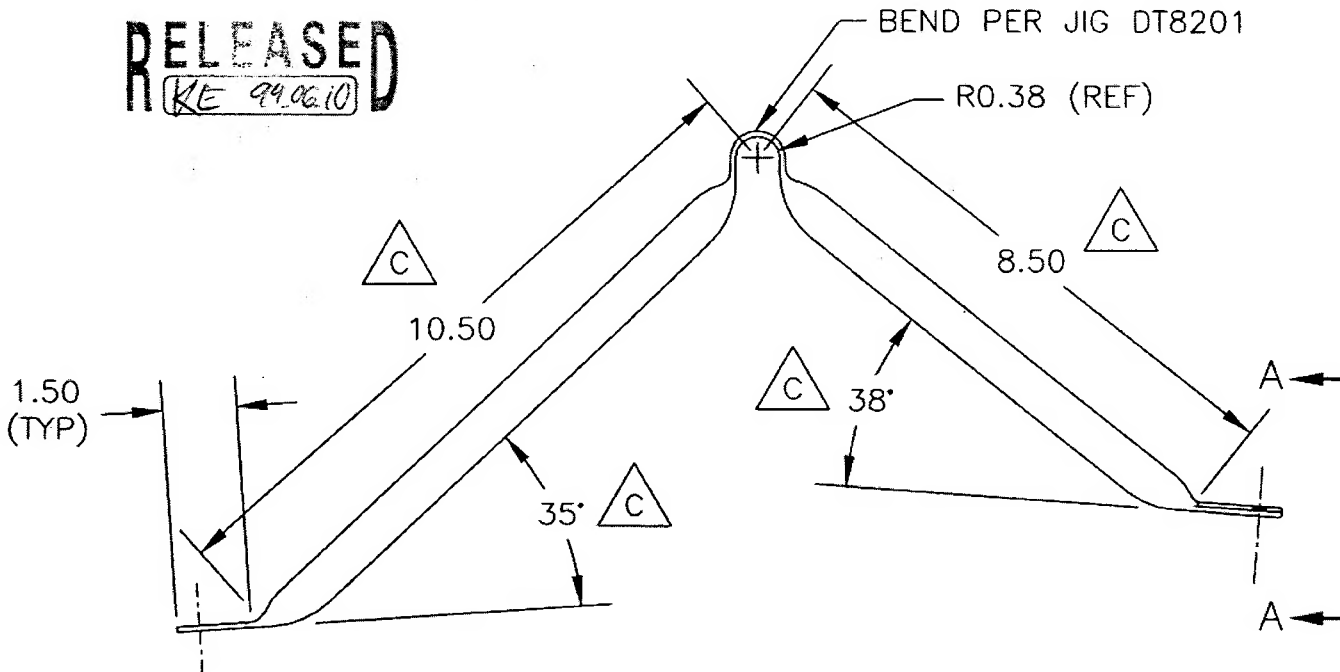
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

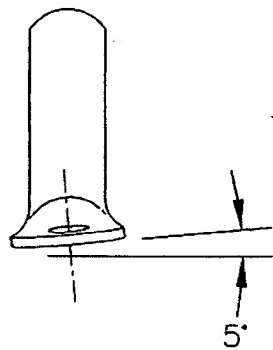
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
KE 99.06.10

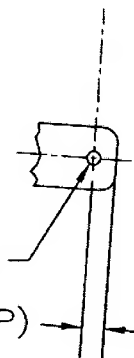


D2013-1 LH SHOWN  
D2013-2 RH OPPOSITE  
(FOR 205 MIRROR)



VIEW A-A

DRILL  $\varnothing 0.257$  (TYP)  
0.400 (TYP)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
375220

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 OD x 0.049 WALL

**DART**



DESIGN	DRAWN BY	DRAWING NO.	REV. C
JB	RF	D2013	SHEET 1 OF 3
CHECKED KE	APPROVED RF	TITLE	SCALE
DATE 99.06.07		MIRROR BRACKET	NTS
A	90.10.22	NEW ISSUE	
B	94.06.15	REDRAWN	
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	

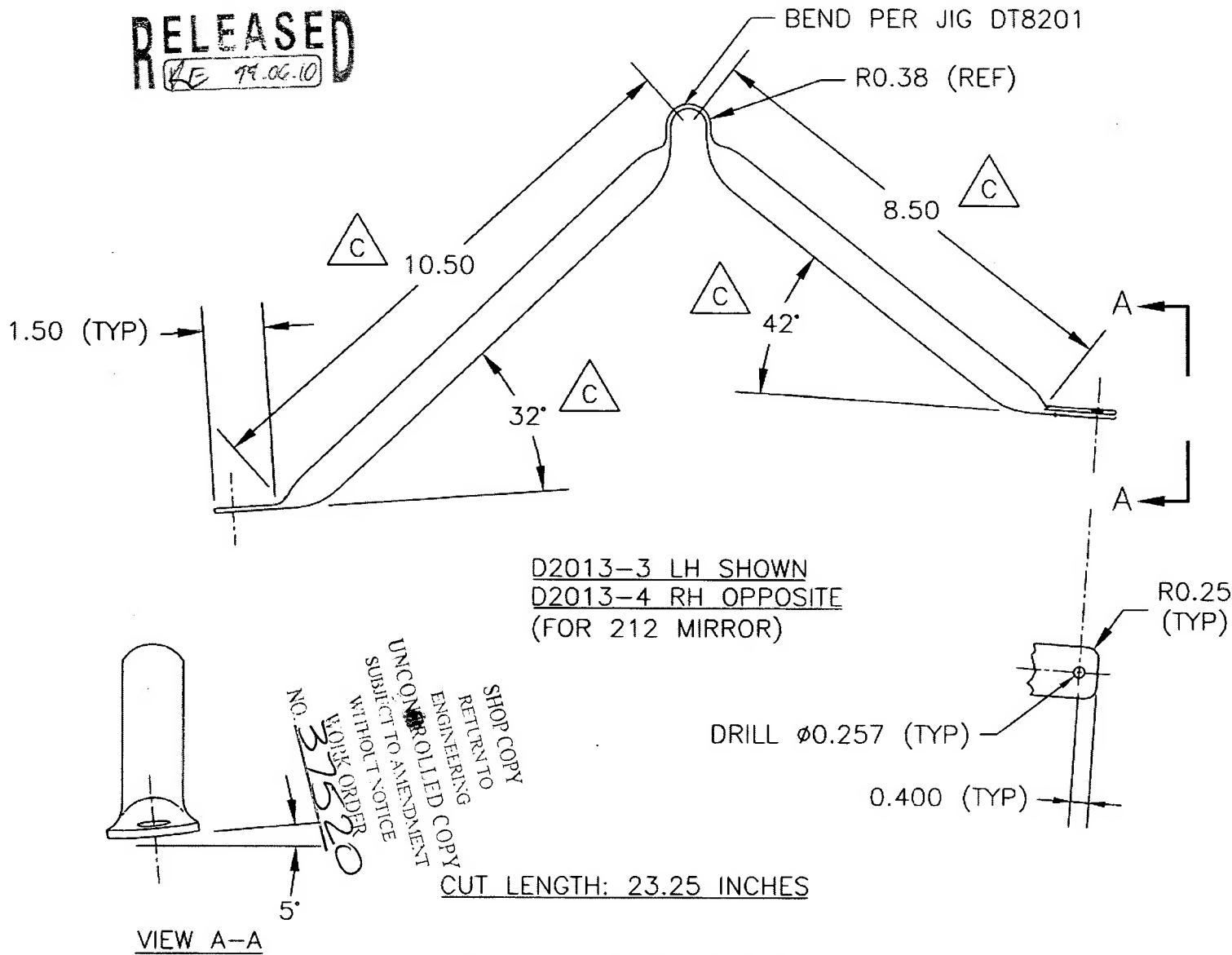


RELEASED  
KE 79.06.10

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	REV. C
JB	RF		
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
KE	[Signature]	D2013	
DATE	TITLE	SCALE	
99.06.07	MIRROR BRACKET	NIS	

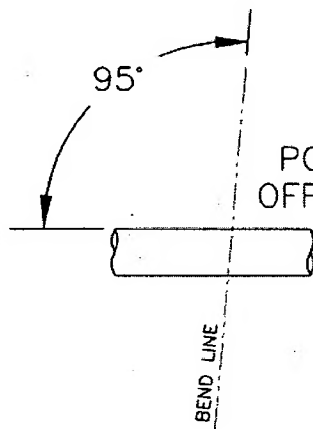
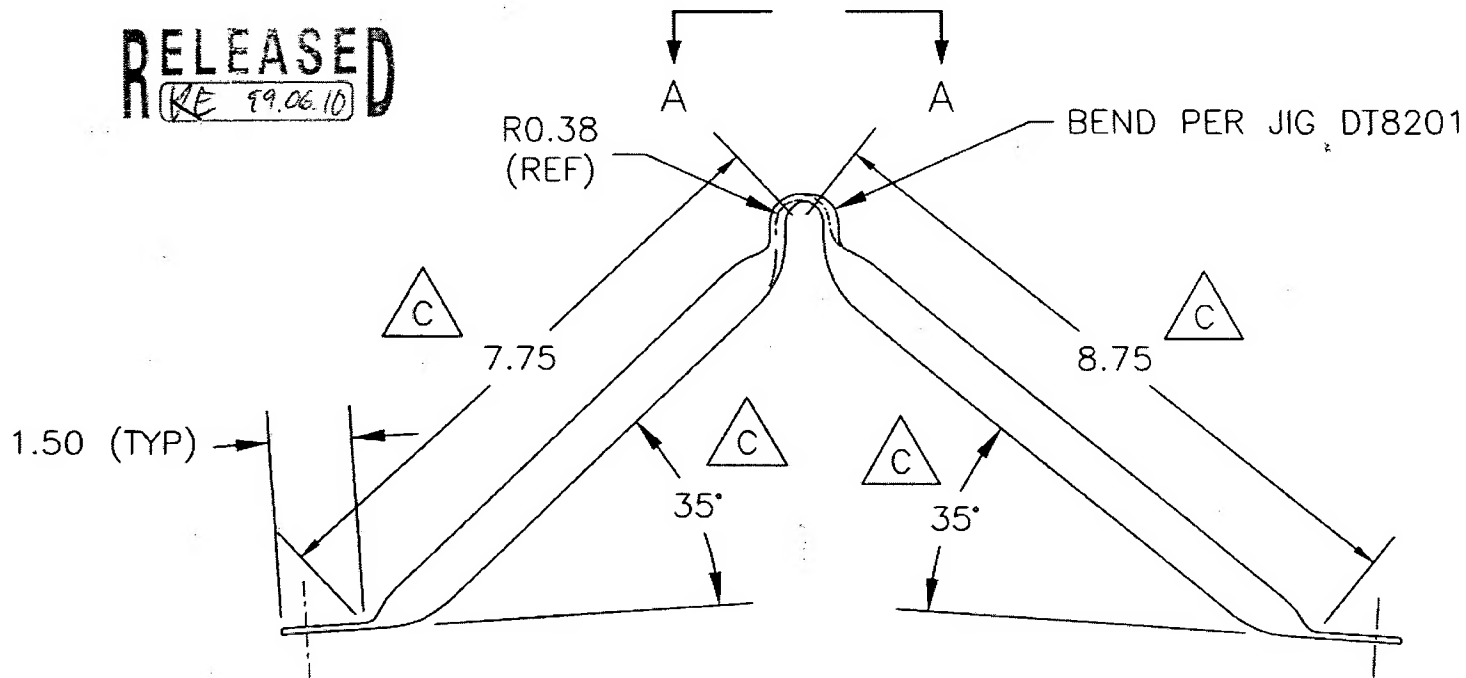


RELEASED  
(KE 99.06.10)

**DART**



DESIGN	JB	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C
				SHEET 3 OF 3
				SCALE
				NTS



VIEW A-A

POSITION TUBE  
OFFSET 5° IN JIG

NO 31520  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AVALANCE  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

D2013-5 LH SHOWN  
D2013-6 RH OPPOSITE  
(FOR 204 MIRROR)

DRILL Ø0.257 (TYP)

0.400 (TYP)

R0.25  
(TYP)

LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL